



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3407-5
Job Sheet 170899



Part No: D3407-5

Job Qty: 20 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/23/18

Job Tracking No:

Due Date: 2/9/18

Created By: Mario Poulin

Type: Stock

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		2/8/18	0.00	0.00	Start Up Waterjet		DC 18/01/28
100	Waterjet	20 pcs		2/8/18	0.03	1.83	Waterjet1		DC 18/01/28
110	QC	20 pcs		2/8/18	0.00	0.00	QC2		DC 18/01/28
115	Lathe Conv	20 pcs		2/9/18	0.00	1.32	Lathe Conv-1		J.C.L.
117	QC	20 pcs		2/9/18	0.00	0.00	QC2		J.C.L. 18-02-07
120	QC	20 pcs		2/9/18	0.00	0.00	QC8		J.F. 18-02-07
130	Packaging	20 pcs		2/9/18	0.00	0.00	Packaging3		DC 18-2-7
140	QC21-SA	20 Ea		2/9/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: _____ Prog Rev: _____ 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

DAS
21
9-00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M174PH-H900B0.250X4.000	17-4 H900 SS Bar 0.250" X 4.000"	5.3200 ft (.266 ea)	90-Start up Operation	

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches ± 0.010	0.260 0.240		
2	Tow Ring	3.000inches ± 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches ± 0.030	0.780 0.720		

Plex 1/23/18 1:52 PM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Ther. ☐																																																																																								
Part No. _____																																																																																												
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Description Work Order Deviation																																																																																												
DART AEROSPACE S036817  Ring PART NO: D3407 - 5 Original Serial #: S036817 Revision: 01/30/18 Operation: Job No: 170899 Change No:																																																																																												
Root Cause																																																																																												
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